

Work Order ID 157867***157867***

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Tuesday, February 28, 2017 10:52:57 AM

Item ID: D3503-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cup

Start Date: 3/1/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 3/6/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MFDate: 28-2-2017

Tooling:

Date:

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3503

B

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.54

Doosan Lathe

1-TURN AS PER FOLIO FA635 & DWG D3503,

FOLIO REV: N/ADWG REV: B

2-DEBURR AS REQUIRED

5017-03-1

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.08

Quality Control

5017-03-01

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.17

Quality Control

504DAS 45 17-3-1 9-89

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Item ID: D3503-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cup
Start Date: 3/1/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 3/6/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.08				50	DA: 6		
Packaging	LOCATION: WA001						8-89		MAR 04 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.83							17/3/16
Quality Control									

DAS
21
9-89

MAR 03 2017

Picklist Print

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Work Order ID: 157867

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Parent Item: D3503-1

D3503-1

Parent Item Name: Cup

Start Date: 3/1/2017

Required Date: 3/6/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 06-05-04 JLM
16.06.14 AS PER DWG REVB1 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased		No		100	f	18.8960	0.065	3.421053			

M304R1 000

304 round bar 1.00

Location

Loc Qty

Loc Code

MAT

18.896

m136568

6.896

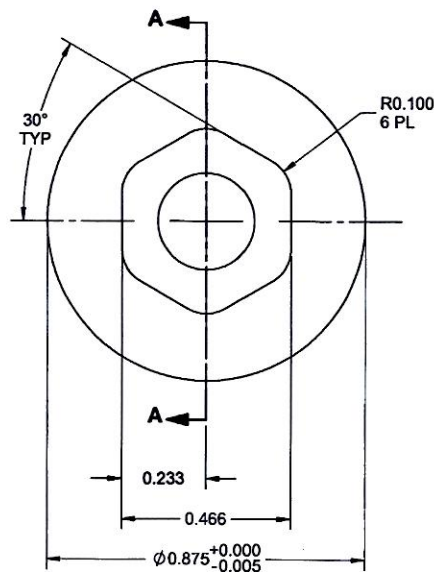
m136896

12

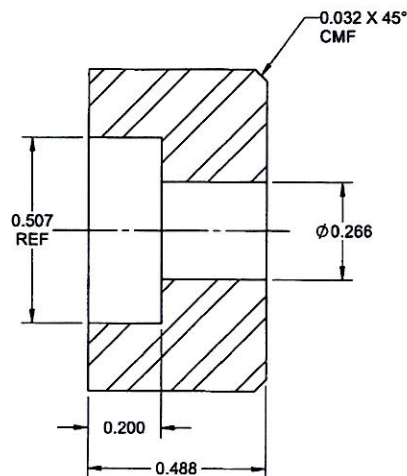
~~2.896~~ 17-03-01

M304R1.000
M136568

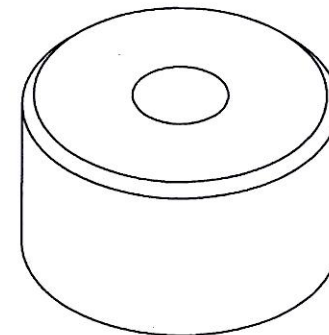
13" 25 1/2



D3503-1 CUP



SECTION A-A



NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR
PER ASTM A276 OR ASTM A240
OR AISI 304/316 ROUND BAR
PER ASTM A276
REF. DART SPEC M304B OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 0.07 lbs

RELEASED
2016-10-18
62-16-64

*mf.
157867*

B	REFORMAT, REDESIGN ADD HEXAGONAL CUTOUT FOR CAPTIVE BOLT. REASON: CIR18-67	AJS	16.06.08
A	NEW ISSUE	PH	08.04.19
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3503	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	CUP	NTS
DATE	16.06.08	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

